

# Work Order ID 84345

**\*84345\***

Page 1

May-10-12 11:24:25 AM

Item ID: D4271-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fwd Beam Assembly  
 Start Date: 10/05/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 24/05/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4271	D

100 0.00  
**\*100\***  
 Small Fab Memo 0.00  
 Small Fab 1- Pick and Assemble as per dwg

110 QC5- Inspect part completeness to step on W/O 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

120 Identify as per dwg & Stock Location: \_\_\_\_\_ 0.00  
**\*120\***  
 Packaging Memo 0.00  
 Packaging

DAS  
16  
8-89

17/05/01

*[Handwritten Signature]*  
12/05/01

12/8/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 84345****\*84345\***

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May-10-12 11:24:25 AM

Item ID: D4271-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Fwd Beam Assembly

Stop **\*NS2\***

Start Date: 10/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/8/13 [Signature]  
MCS 12/08/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-10-12 11:24:28 AM

Page 1

Work Order ID: 84345

**\*84345\***

Parent Item: D4271-011

**\*D4271-011\***

Parent Item Name: Fwd Beam Assembly

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC  
11.01.26 RevB dwg EC verified by:DD  
per PD1 EC verified by:JLM

IPP RevA  
IPP RevC 11.07.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4271-025		Manufactured	No			100	Each	1.0000	1	1			
<b>*D4271-025*</b>									<b>**</b>				
End Fitting Assembly Fwd Beam													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST512				1					
				72266				1					
D4275-1		Manufactured	No			100	Each	4.0000	1	1			
<b>*D4275-1*</b>									<b>**</b>				
Fwd Beam													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st1638				2					
				74709				2					
				ST168				2					
				80594				2					

*Handwritten notes:*  
B12/08/01  
B87771  
B12/08/01  
B82642  
(K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-10-12 11:24:28 AM

Page 2

Work Order ID: 84345

**\*84345\***

Parent Item: D4271-011

**\*D4271-011\***

Parent Item Name: Fwd Beam Assembly

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C12A

Purchased

No

100

Each

297.0000

6

6

**\*AN3C12A\***

Bolts

\*\*

*EP 12/08/01*

Location

Loc Qty

Loc Code

GA

40

120449

40

ST351

257

117514

4

118112

5

118451

22

119510

1

120423

125

121584

50

121689

50

MS21043-3

Purchased

No

100

Each

1,827.0000

6

6

**\*MS21043-3\***

Nut

\*\*

*M1224/16*  
*EP 12/08/01*

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

78

120693

78

ST301

1677

118077

2

118614

51

118686

30

119758

20

121255

574

121708

1000

May-10-12 11:24:29 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

May-10-12 11:24:29 AM

Page 3

Work Order ID: 84345

\*84345\*

Parent Item: D4271-011

\*D4271-011\*

Parent Item Name: Fwd Beam Assembly

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

100

Each

3,870.000

12

12

**\*NAS1149C0332R\***

\*\*

Washer

Location

Loc Qty

Loc Code

ST297

219

119736

196

120648

23

ST298

3651

121255

11

121509

3640

EB 12/08/01

M122063  
120

May-10-12 11:24:29 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

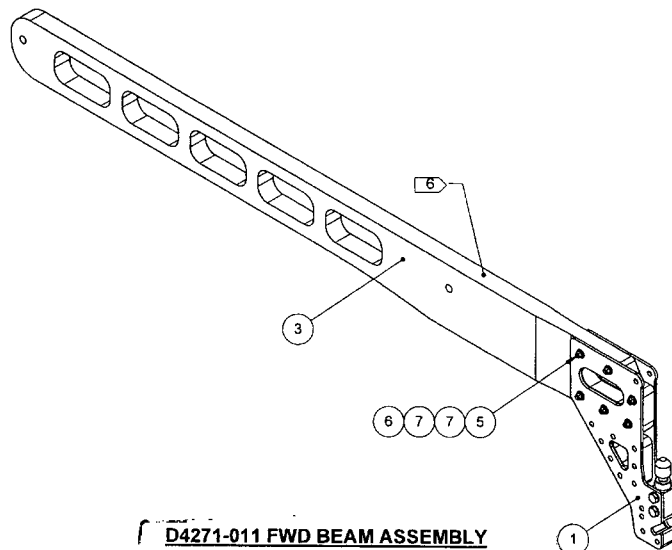
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

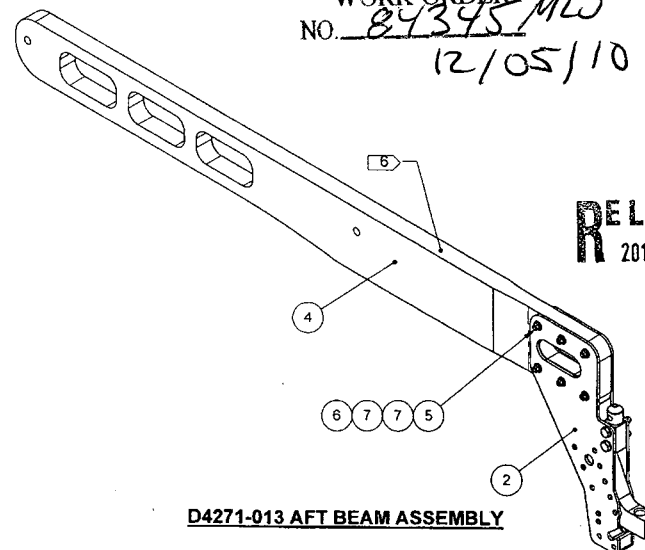
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -011	QTY -013	P/N	DESCRIPTION
	X		D4271-011	FWD BEAM ASSEMBLY
		X	D4271-013	AFT BEAM ASSEMBLY
	-	-	D4271-021	DELETED AT REVISION D
	-	-	D4271-023	DELETED AT REVISION D
1	1	-	D4271-025	FWD BEAM END FITTING ASSEMBLY
2	-	1	D4271-027	AFT BEAM END FITTING ASSEMBLY
3	1	-	D4275-1	FWD BEAM
4	-	1	D4276-1	AFT BEAM
5	6	6	AN3C12A	BOLT
6	6	6	MS21043-3	NUT
7	12	12	NAS1149C0332R	WASHER



**D4271-011 FWD BEAM ASSEMBLY**



**D4271-013 AFT BEAM ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 84345 MLJ  
12/05/10

**RELEASED**  
2011-07-28

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-0XX" AND B/N "BXXXXX"  
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -011: 11.02 lbs  
-013: 12.97 lbs

D	DELETED -021 & -023 REPLACED BY -025 & -027 FOR Q.R. STEP INSTALLATION.	AJS	11.07.14
C	ADDED -021 & -023 FOR EASE OF CONFIGURATION MANAGEMENT. REFORMAT SEE PREV REV FOR DETAILS.	AJS	11.07.12
B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4271	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SUPPORT BEAM ASSEMBLIES	NTS
DATE	11.07.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

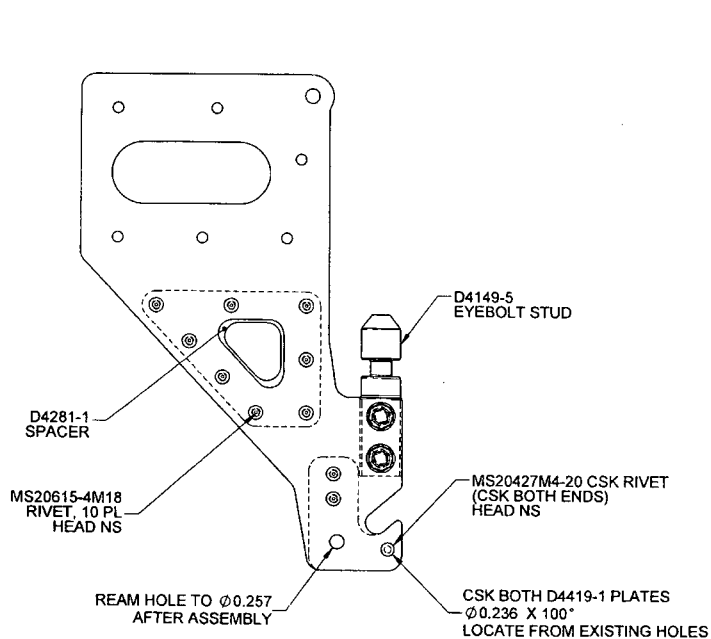
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

04345

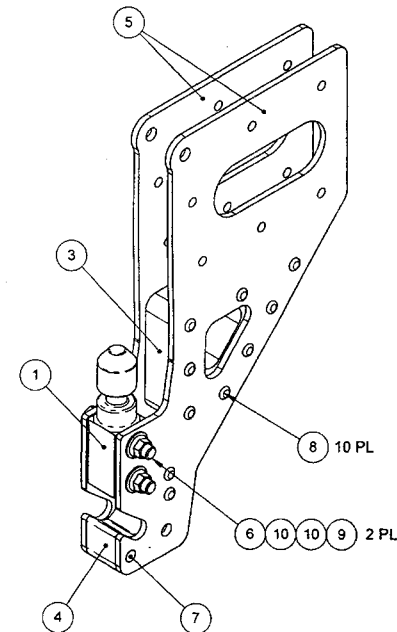
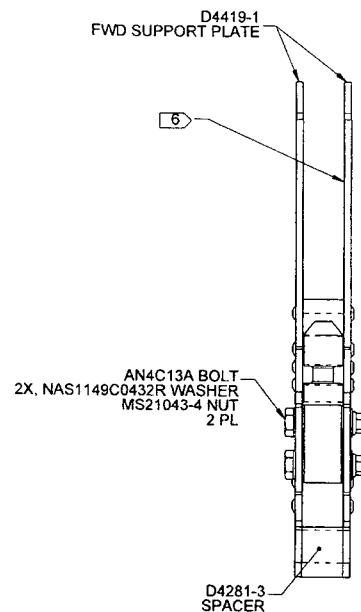
ITEM	QTY	P/N	DESCRIPTION
	X	D4271-025	FWD BEAM END FITTING ASSEMBLY
1	1	D4149-5	EYEBOLT STUD
3	1	D4281-1	SPACER
4	1	D4281-3	SPACER
5	2	D4419-1	FWD SUPPORT PLATE
6	2	AN4C13A	BOLT
7	1	MS20427M4-20	CSK RIVET (MONEL)
8	10	MS20615-4M18	RIVET (MONEL)
9	2	MS21043-4	NUT
10	4	NAS1149C0432R	WASHER







**D4271-025 FWD BEAM END FITTING ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-025" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.69 lbs



**RELEASED**  
2011-07-28

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4271	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SUPPORT BEAM ASSEMBLIES</b> NTS	
DATE	11.07.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

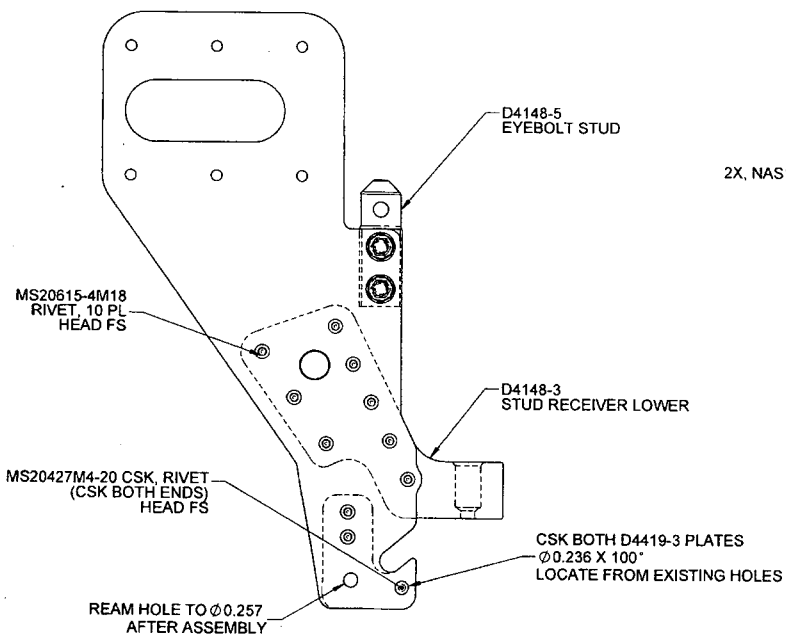
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

84345

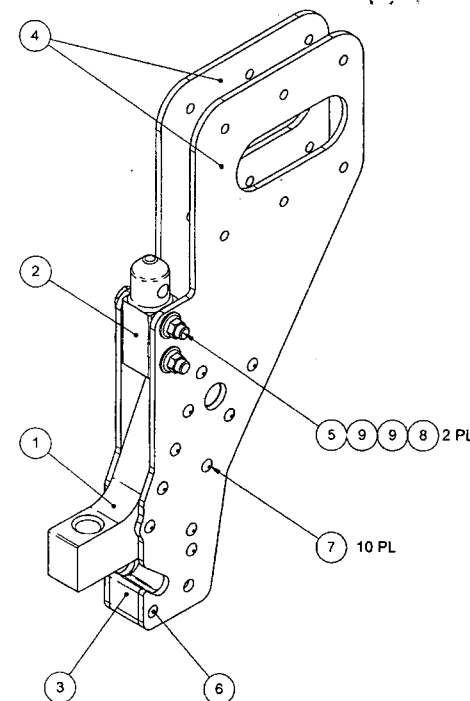
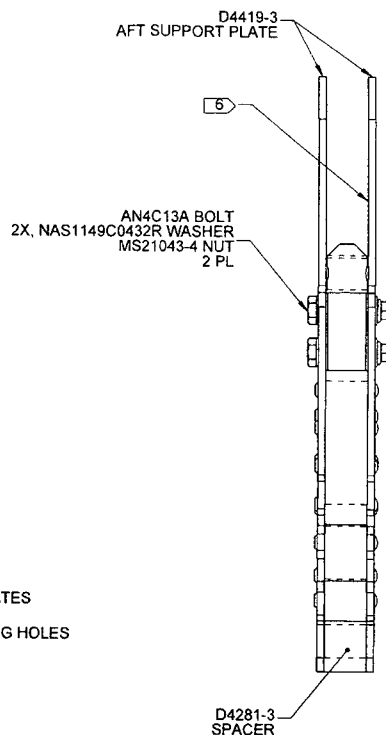
ITEM	QTY -027	P/N	DESCRIPTION
	X	D4271-027	AFT BEAM END FITTING ASSEMBLY
1	1	D4148-3	STUD RECEIVER LOWER
2	1	D4148-5	EYEBOLT STUD
3	1	D4281-3	SPACER
4	2	D4419-3	AFT SUPPORT PLATE
5	2	AN4C13A	BOLT
6	1	MS20427M4-20	CSK RIVET (MONEL)
7	10	MS20615-4M18	RIVET (MONEL)
8	2	MS21043-4	NUT
9	4	NAS1149C0432R	WASHER



**D4271-027 AFT BEAM END FITTING ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-027" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 4.25 lbs



**RELEASED**  
2011-07-28

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4271	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SUPPORT BEAM ASSEMBLIES</b>	
DATE	11.07.14	NTS	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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